



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3411

Job Sheet 178092



Part No: 646.3411

Job Qty: 40 ea

Part Name: RH Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C SHEET 1 IPP REV:A NEW ISSUE 13/02/21 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		5/31/18	0.00	0.00	Start Up Machining-1		mm L 18/06/27
100	Bandsaw	10 pcs		5/31/18	0.00	0.01	Bandsaw1		u
110	CNC Vertical Machining	10 pcs		5/31/18	0.00	17.01	HAAS1-1		u
120	QC	10 pcs		5/31/18	0.00	0.00	QC2 Machining-1		u
130	QC	10 pcs		5/31/18	0.00	0.00	QC8 Machining-1		A-c 18-06-27
140	Outsource	10 pcs		5/31/18			ATG001-VC	10	CT 18-06-27
150	Packaging	10 pcs		5/31/18	0.00	0.00	Packaging2		mod 18-07-04
155	QC	10 pcs		5/31/18	0.00	0.00	QC5		38
180	Packaging	10 pcs		5/31/18	0.00	0.00	Packaging3-1		JUL 05 2018
190	QC21-SA	10 Ea		5/31/18	0.00	0.00	QC21		JUL 05 2018

Part Op 100 - Cut Blank at 7.125"

Descriptions: 110 - 1-Machine per folio FB151 DWG REV: FOLIO REV: 2- deburr and break all sharp edges

140 - Issue P/O to ATG 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S4.000X3.000	7075-T6S Sheet 4.000" Thick X 3.000" Wide	5.9400 ft (.594 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S4.000X3.000	6	61	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S084693

Part: 646.3411

Job No: 178092

Serial No/Batch: S084693

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/27/18

Specifications

Dimension	Limits	Type	Special Comments
1.010	3.960		
	3.940		
1.010	5.060		
	5.040		
± 0.500	70.500	Angle	
	69.500		
± 0.500	40.500	Angle	
	39.500		

Plex 5/28/18 7:21 AM Dart.lajeunesse.marie

5	Wiper Deflector, RH	0.500inches $\pm$ 0.010	0.510 0.490	Radius
6	Wiper Deflector, RH	0.250inches $\pm$ 0.010	0.260 0.240	
7	Wiper Deflector, RH	1.100inches $\pm$ 0.010	1.110 1.090	
8	Wiper Deflector, RH	0.310inches $\pm$ 0.010	0.320 0.300	
9	Wiper Deflector, RH	45.000inches $\pm$ 0.500	45.500 44.500	
10	Wiper Deflector, RH	0.190inches $\pm$ 0.010	0.200 0.180	Radius
11	Wiper Deflector, RH	6.880inches $\pm$ 0.010	6.890 6.870	
12	Wiper Deflector, RH	6.250inches $\pm$ 0.010	6.260 6.240	
13	Wiper Deflector, RH	5.740inches $\pm$ 0.010	5.750 5.730	
14	Wiper Deflector, RH	4.630inches $\pm$ 0.010	4.640 4.620	
15	Wiper Deflector, RH	0.500inches $\pm$ 0.010	0.510 0.490	Radius
16	Wiper Deflector, RH	1.630inches $\pm$ 0.010	1.640 1.620	
17	Wiper Deflector, RH	3.000inches $\pm$ 0.010	3.010 2.990	
18	Wiper Deflector, RH	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle
19	Wiper Deflector, RH	0.190inches $\pm$ 0.010	0.200 0.180	Radius
20	Wiper Deflector, RH	0.750inches $\pm$ 0.010	0.760 0.740	
21	Wiper Deflector, RH	2.750inches $\pm$ 0.010	2.760 2.740	
22	Wiper Deflector, RH	0 $\pm$ 0		
23	Wiper Deflector, RH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle
24	Wiper Deflector, RH	0.380inches $\pm$ 0.010	0.390 0.370	

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646.3400

JS

Jean Francois Sauve

Reply all |

Today, 9:27 AM
Linda Lacelle; Me

FYI

From: Pablo Bravo
Sent: June-26-18 9:25 AM
To: Jean Francois Sauve <jfsauve@dartaero.com>
Subject: RE: 646.3400

JF,

It is acceptable to use T73 for this part temporarily.

Pablo

From: Jean Francois Sauve
Sent: Monday, June 25, 2018 10:43 AM
To: Pablo Bravo <pbravo@dartaero.com>
Subject: RE: 646.3400

Hi Pablo,

Any news on this?

Jean-Francois.

From: Jean Francois Sauve
Sent: June-18-18 1:45 PM
To: Pablo Bravo <pbravo@dartaero.com>
Subject: 646.3400

Hi Pablo,

646.3411 Wiper Deflector have been machined out of M7075T73. The drawing calls for M7075T6. Is this acceptable?

One part is affected.

Thanks

JEAN-FRANÇOIS SAUVÉ
Production Engineering Coordinator

DART AEROSPACE

T 1 613 632-5200 > 237

F 1 613 632-5246

1 800 556-4166

www.dartaerospace.com



646:3411

Pablo Bravo

|

Today, 9:30 AM

Hi Linda,

I just replied to JF. T73 is okay for this batch. I think in the future there's a strong preference for T6.

Pablo



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915493

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: D2348 Rev: C Wearplate (Key Way) Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Job: 23360 PO: PO040341 Line: 1		
10 ea	Part: 646.3411 Rev: NC RH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23361 PO: PO040341 Line: 2		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>9/7/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

DAS
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9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040341

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040341
PO Date: 6/26/18
Due Date: 7/13/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179538	D2348	Wearplate (Key Way) Issue P/O: _____ Black Anodize per Dwg D2348 Rev. C	Firmed	7/13/18	20 pcs	0 pcs	20 pcs	\$6.00/pcs	\$120.00
2	179951	646.3411	RH Wiper Deflector Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400	Firmed	7/13/18	3 pcs	0 pcs	3 pcs	\$27.00/pcs	\$81.00
	179952			Firmed	7/13/18	6 pcs	0 pcs	6 pcs	\$27.00/pcs	\$162.00
	178092			Firmed	7/13/18	1 pcs	0 pcs	1 pcs	\$27.00/pcs	\$27.00
Sub Total:						10	0	10		\$270.00

Grand Total: \$390.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT.

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Plex 6/27/18 3:05 PM dart.tsimiklis.chrisoula